

Date: Monday, 07/07/2008 4:23:34 PM  
 User: Julie Lecocq

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
 Job Number : 40348 *3*  
 Estimate Number : 13371  
 P.O. Number :  
 This Issue : 07/07/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SMALL / MED FAB  
 Previous Run : 05032  
 Written By :  
 Checked & Approved By : *JUL 08.7.07*  
 Comment : Est Rev:A 08-06-09 new issue DD verified by:ec

Drawing Name : HANDLE ASSEMBLY (EXTERIOR) *Sheet*  
 Part Number : D3779041  
 Drawing Number : D3779 REV A  
 Project Number : N/A  
 Drawing Revision : A  
 Material :  
 Due Date : 28/07/2008  
 Qty: *13* Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 M6061T6S125 6061-T6 .125 Sheet



Comment: Qty.: 0.2037 sf(s)/Unit Total: 2.0370 sf(s)

6061-T6 .125 Sheet

batch: *106634* *HB 8-7-14*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3779

Dwg Rev: *A*

Prog Rev: *A*

*HB 8-7-14*

*14*

2-Deburr if necessary

*HB 8-7-14*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*006/15 (x14)*

*PRD*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HANDLE ASSEMBLY (EXTERIOR)

Job Number: 40348

Part Number: D3779041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D32031

Handle



Comment: Qty.: 1.0000 Each(s)/Unit Total: 10.0000 Each(s)

Handle

batch: 40353

Res/28 (11)

7.0

MS20426AD10 18

Rivet Countersunk



Comment: Qty.: 4.0000 Each(s)/Unit Total: 40.0000 Each(s)

Rivet Countersunk

batch: 1107736

or (MS20426AD10-10)

448

B

D3779-041  
3 stock

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

11/08/07/21

1- counter sink holes as per dwg D3779

2- deburr

3- rivet D3203-1 handle to D3779-1 plate as per dwg D3779 per QSI003

SB 08/10/10

(3)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/10/10 (x3)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with Dart part # using a fine point permanent marker and Stock

Location: 5 238A

SS 8/10/10 (x3)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



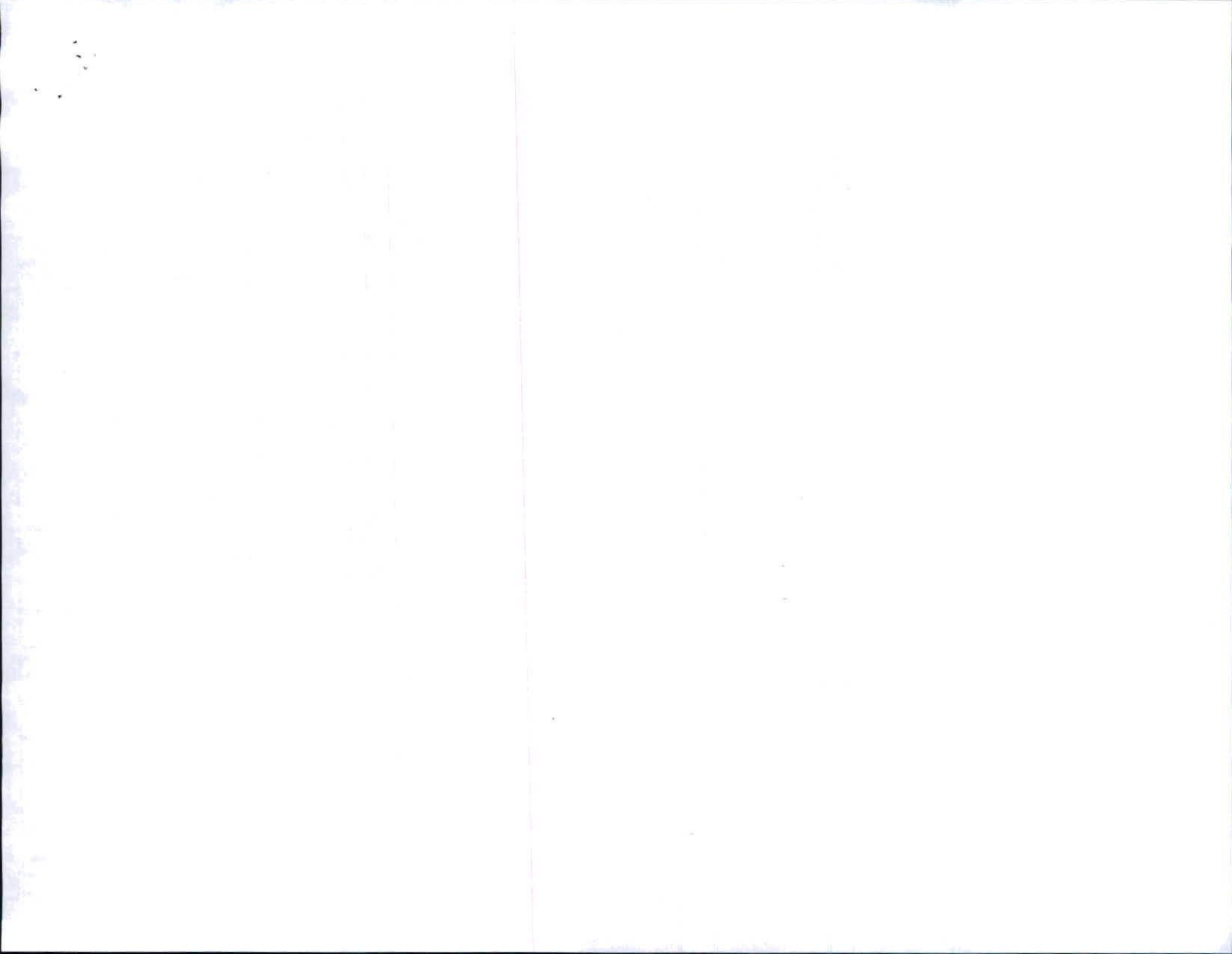
Comment: FINAL INSPECTION/W/O RELEASE

08/10/10

Job Completion



12 08.10.10

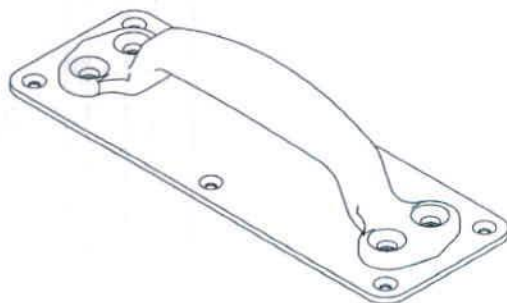




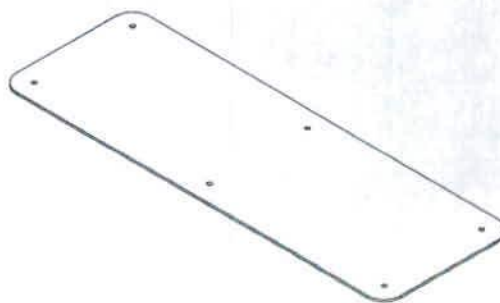




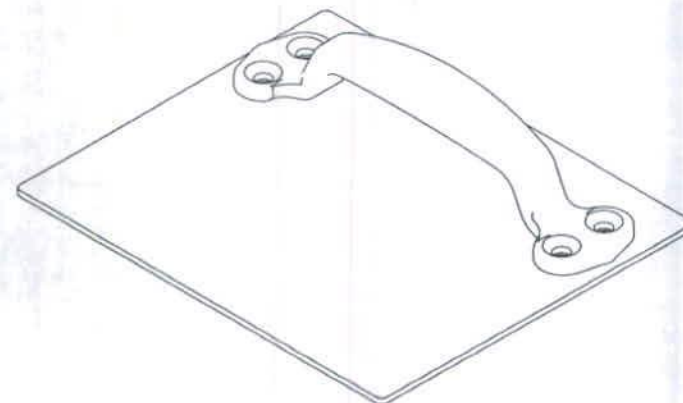
QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
X		D3779-041	HANDLE ASSEMBLY
	X	D3779-043	HANDLE ASSEMBLY
1	1	D3203-1	HANDLE
1		D3779-1	PLATE
	1	D3779-5	PLATE
4	4	MS20426AD10-8	RIVET, CSK



**D3779-041 HANDLE ASSEMBLY**  
(EXTERIOR)



**D3779-3 DOUBLER PLATE**



**D3779-043 HANDLE ASSEMBLY**  
(INTERIOR)

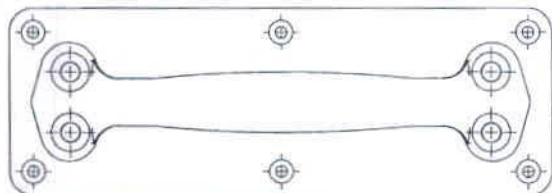
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15-06-21

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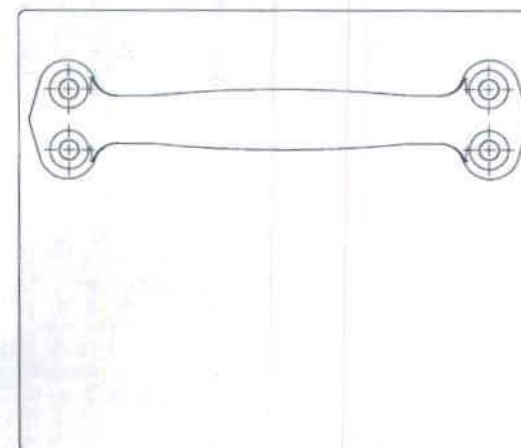
A	NEW ISSUE	AJS	08.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA DRAWING NO. <b>D3779</b> TITLE <b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b> SCALE <b>NTS</b>	
DRAWN	AJS		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.21	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD          THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR COMMUNICATION TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



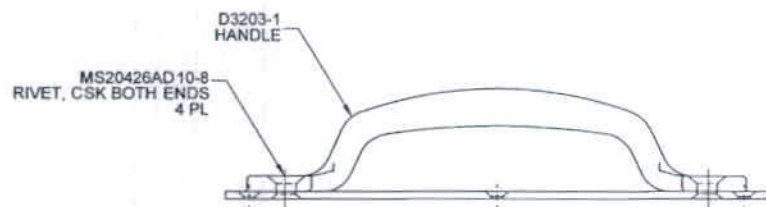




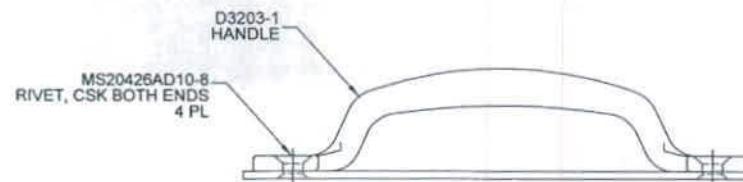
D3779-1  
PLATE



D3779-5  
PLATE



**D3779-041 HANDLE ASSEMBLY  
(EXTERIOR)**



**D3779-043 HANDLE ASSEMBLY  
(INTERIOR)**

**NOTES:**

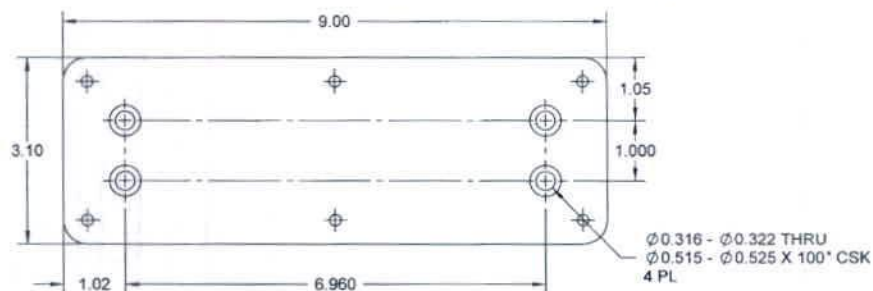
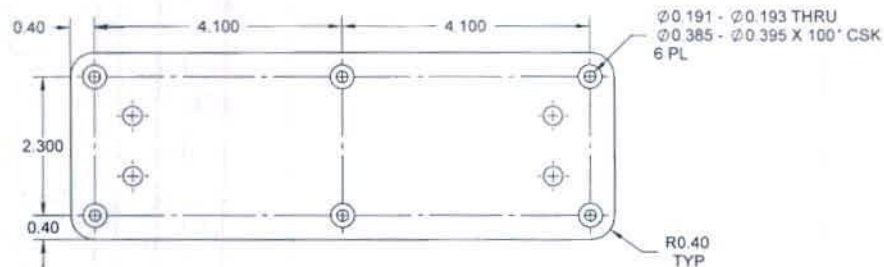
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-041" USING FINE POINT PERMANENT INK MARKER
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-043" USING FINE POINT PERMANENT INK MARKER
- 8) WEIGHT: 0.71 lbs APPROX (-041)
- 9) WEIGHT: 1.14 lbs APPROX (-043)

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MFG. APPR.		SHEET 2 OF 4	
APPROVED		TITLE <b>HANDLE ASSEMBLY, CABIN SLIDING DOOR</b>	SCALE NTS
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**D3779-1 PLATE**

**NOTES:**

1) MATERIAL: -1 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.125

-3 PLATE:

6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.050 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.050

2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

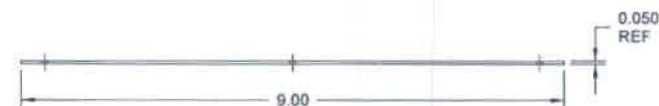
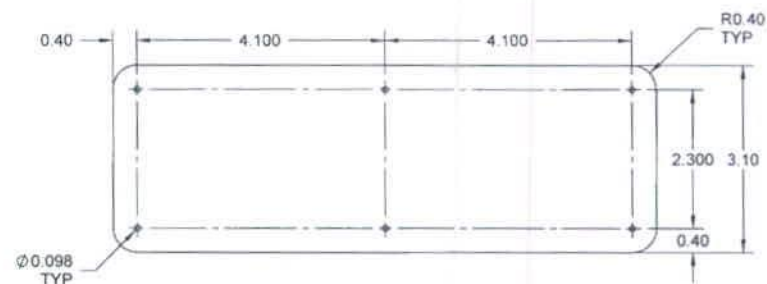
4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3779-3" USING FINE POINT PERMANENT INK MARKER  
(DO NOT IDENTIFY -1 & -5)

7) WEIGHT: 0.14 lbs FOR -3.

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**D3779-3 PLATE**

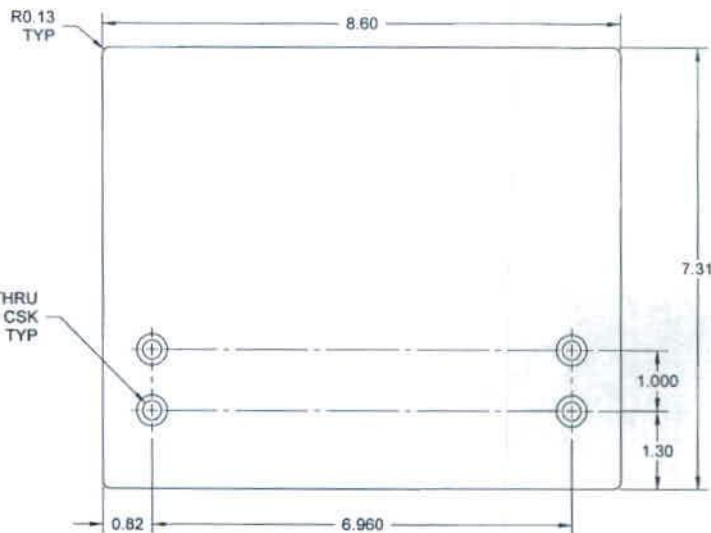
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MFG. APPR.		D3779	SHEET 3 OF 4
APPROVED		TITLE	SCALE
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Ø0.316 - Ø0.322 THRU  
Ø0.515 - Ø0.525 X 100° CSK  
TYP



**D3779-5 PLATE**



**NOTES:**

- 1) MATERIAL: -5 PLATE:  
6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.125 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.125
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: SEE SHEET 2 FOR ASSEMBLED WEIGHT

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CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3779	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		HANDLE ASSEMBLY, CABIN SLIDING DOOR	NTS
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